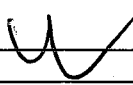
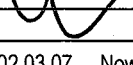


Date: Tuesday, 20/03/2007 9:11:06 AM
 User: Linda Lacelle











Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BUSHING	<i>For Arm 30538 D3560-2</i>
Job Number : 31326		
Estimate Number : 11041		
P.O. Number : <i>N/A</i>	Part Number : D2809	
This Issue : 20/03/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2809 REV A1	
Prsht Rev. : NC	Project Number : N/A	
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : A1	
Previous Run : 30749	Material : <i>N/A</i>	
Written By : 	Due Date : 27/03/2007	Qty: 4 Um: Each
Checked & Approved By : 		
Comment : Est C 02.03.07 Now turned in house NG		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6R0500	6061-T6 Round Bar .500"
		
	Comment: Qty.: 0.1045 f(s)/Unit Total: 0.4179 f(s) 6061-T6 Round Bar .500" Material: 6061-T6 (QQ-A-250-11) rod .500"Ø <i>.625</i> Batch: <i>18746</i> <i>BG 07.03.20 (4)</i>	
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
		
	Comment: HARDINGE CNC LATHE SMALL Machine as per Folio FA204 <i>BG 07.03.20 (4)</i>	
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE <i>BG 07.03.20 (4)</i>	
4.0	QC8	SECOND CHECK
		
	Comment: SECOND CHECK <i>EN 07.03.20 (x4)</i>	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
		
	Comment: SMALL & MEDIUM FAB RESOURCE 1 Tumble & deburr all sharp edges as per dwg <i>BG 07.03.20 (4)</i>	

Date: Tuesday, 20/03/2007 9:11:07 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BUSHING

Job Number: 31326

Part Number: D2809

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

LE 07-03-20

7.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder coat WHITE per QSI 005 4.3

N/A As per
serge approval
on Dwg.

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *W1425*

LE 07-03-20

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

4
Done 03/02

Job Completion:

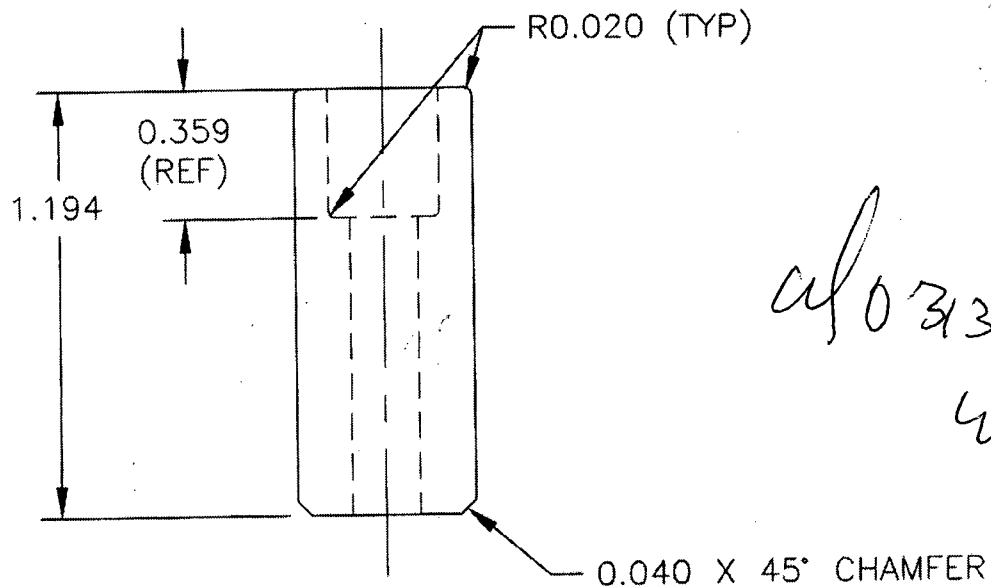
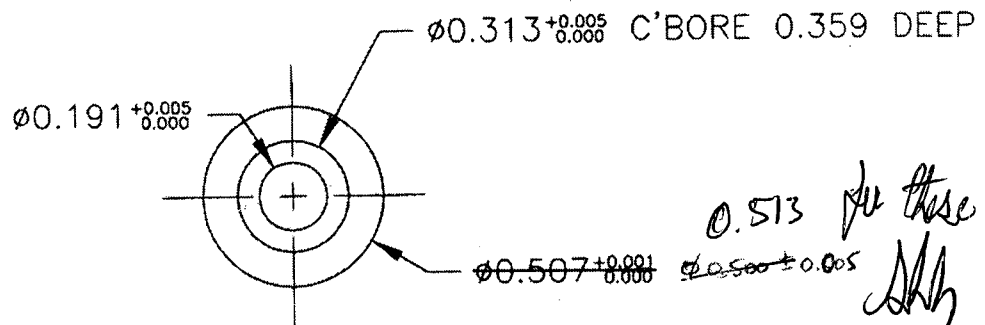


U 07-03-21



DESIGN <i>[initials]</i>	DRAWN BY <i>[initials]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[initials]</i>	APPROVED <i>[initials]</i>	DRAWING NO. D2809	REV. A SHEET 1 OF 1
DATE 00.11.07		TITLE SPACER	SCALE 2:1
A	00.11.07	NEW ISSUE	
A1	<i>[initials]</i> 01.04.26	ADD POWDER COAT; $\phi 0.500$ WTS $\phi 0.507$	

RELEASED
00.11.13 *[initials]*



TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

BREAK ALL UNMARKED SHARP CORNERS 0.010 TO 0.020

MATERIAL: 6061-T6 (QQ-A-250/11) OR (QQ-A-225/8)

FINISH: ~~CHEMICAL CONVERSION COAT PER DART QSI 005 4.1~~ *complete*

~~POWDER COAT WHITE (4.3.5.1) OR GRAY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8)~~

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DART AEROSPACE LTD		Work Order: 31326
Description: Spacers		Part Number: D2809
Inspection Dwg: D2809 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A $\phi .191$	$\pm .005$ $- .000$.194	✓			
B $\phi .313$	$\pm .005$ $- .000$.318	✓			
C .359	$\pm .010$.360	✓			
D .513	$\pm .001$.514	✓			
E 1.194	$\pm .010$	1.198	✓			
F .020 R	$\pm .01$.02	✓			
G .040 x 45°	$\pm .010$.040	✓			
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: <i>BL</i>	Audited by: <i>EP</i>	Prototype Approval:	N/A
Date: 07.03.20	Date: 07/03/20	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	